

Work Order ID 65081

Thursday, January 06, 2011 9:51:10 AM



Page 1

Item ID: D3220-3

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 1/6/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date: *11-01-11*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3220

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3220

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

B11-1-11

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-11

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

Subtotal



QC

Memo

0.00

Quality Control

(42)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 0 11/01/13

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BR 11-01-13.

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 180A

0.00



Packaging

Memo

0.00

Packaging

11/01/14 (12)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/1411/01/14

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Picklist Print

Thursday, January 06, 2011 9:51:14 AM

Page 1

Work Order ID: 65081



Parent Item: D3220-3



Parent Item Name: Doubler



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 05-11-06 JLM
IPP: B 06.11.15 waterjet EC
IPP C: 08.11.26 Comment added to step 2 KJ Verified by: eC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050 		Purchased		No		100	sf	69.9847	0.5937	6.249474	7.2		
											11-1-11		

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

69.9847

111381

11.89

113189

0.3947

114968

57.7

114968

(12)

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Item	Qty -041	Qty -042	Part Number	Description
1	X		D3220-041	DOUBLER ASSEMBLY
2		X	D3220-042	DOUBLER ASSEMBLY
3	1		D3220-1	DOUBLER
4		1	D3220-2	DOUBLER
5	4	4	MS21059L4	NUTPLATE
6	8	8	MS20426AD3-3	RIVET


 MS21059L4 NUTPLATE
 MS20426AD3-3 RIVET, 2X
 4 PL

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 45081
PS11-01-6

RELEASED
 2009-09-09
MD

D3220-041 DOUBLER ASSEMBLY (SHOWN WITH D3220-1 DOUBLER)
D3220-042 (OPPOSITE)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3220-041 = 0.53 lbs
D3220-042 = 0.53 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. Ø0.316 WAS Ø0.323 (ZN C8-2, B4-3); MS20426AD3-3 WAS MS20426AD3-4 (ZN D4-1); CORRECT TYPO NOTE 1 (ZN A8-2, A8-3); REF PAR 09-025		RF	09.07.08
A	NEW ISSUE		CP	03.10.16
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3220	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		DOUBLER	NTS	
DATE	09.07.08		COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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w/o 65081

8 7 6 5 4 3 2 1

D

C

B

A

Ø0.098
CSK Ø0.180x100°
NEAR SIDE, 8 PL

B
Ø0.316
TYP, 4 PL

GRAIN
DIRECTION

0.500 TYP

1.000 TYP

R0.50
TYP

14.25

7.000

5.50

1.50

1.000

7.00

B1-2

SEE DETAIL A
TYP

100°
REF

0.050
REF

DETAIL A
SCALE 5X

D3220-1 DOUBLER

RELEASED
2009-09-09
WJ

B

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SP	DRAWING NO.	REV. B
MFG. APPR.		D3220	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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8 7 6 5 4 3 2 1

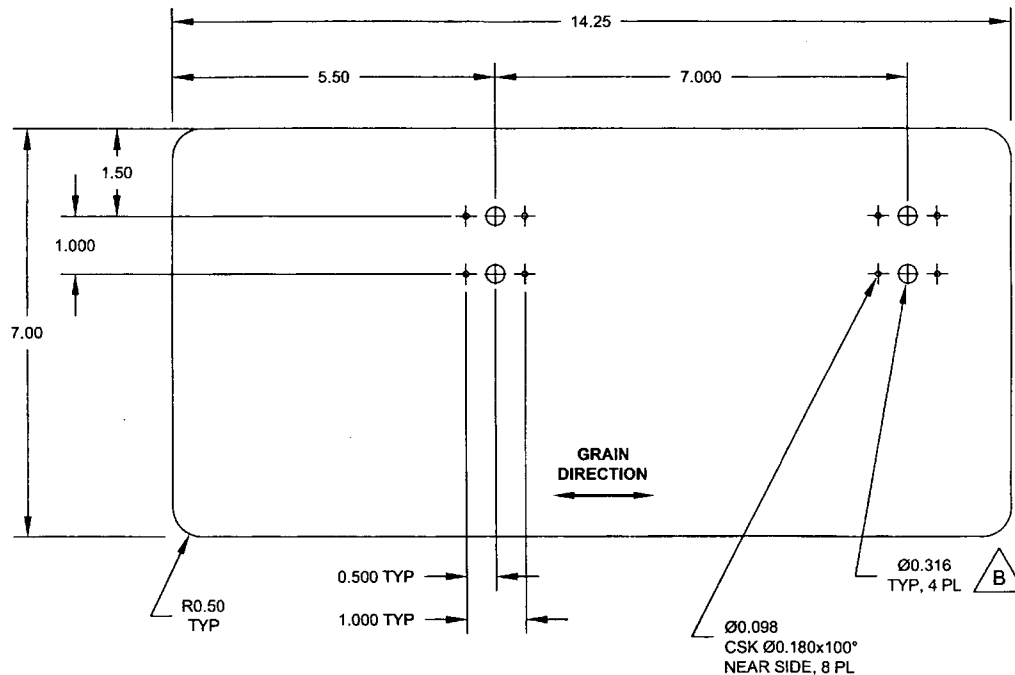
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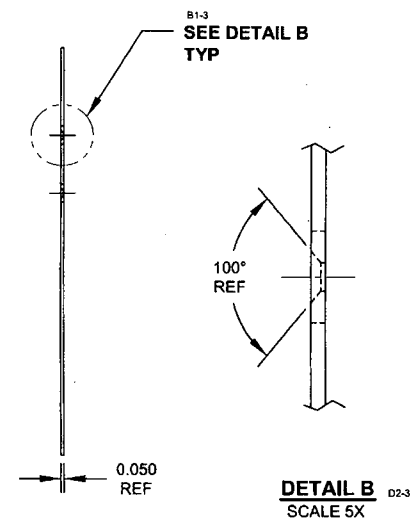
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D3220-2 DOUBLER

w/065087



RELEASED
2009-09-09



NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC. M2024T3S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3220-2" USING REMOVABLE TAG
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3220	SHEET 3 OF 4
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DE APPR.	RF	DOUBLER	NTS
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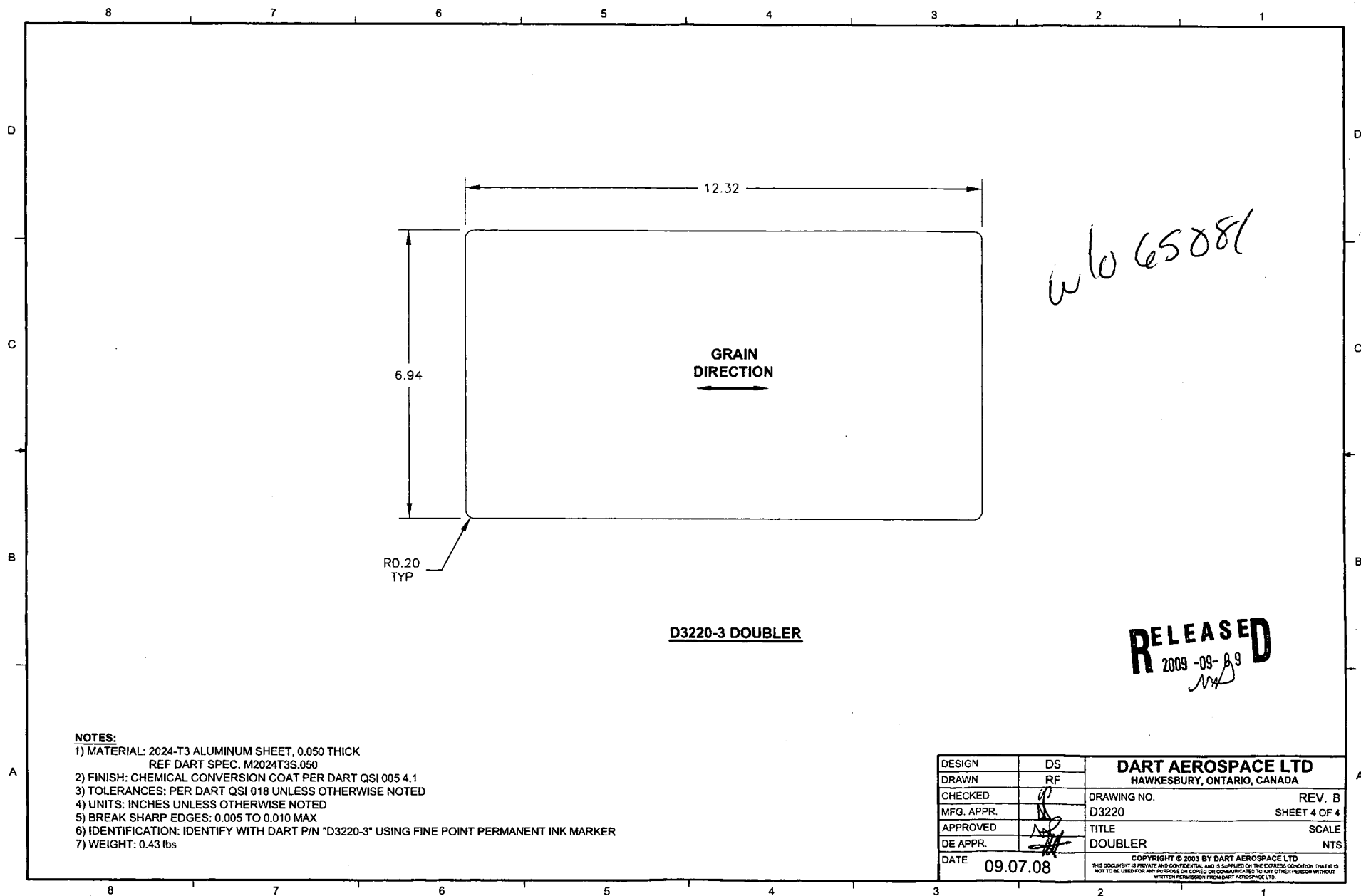
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